

Work Order ID 120292


June-20-14 10:38:31 AM

120292

Page 2

Item ID: 646.3511 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut
 Start Date: 6/13/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 6/13/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115		0.00							
115									
Purchasing	Memo	0.00							
Purchasing	ISSUE PO: 								
	CUT AS PER DRWG: 646.3500 N/C3								
140		0.00							
140									
Small Fab	Memo	0.00							
Small Fab	1- Fabricate tube as per dwg								
150		0.00							
150	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

10 14-09-10 MAL

PC 14-9-10

10

Work Order ID 120292

120292

Page 3

June-20-14 10:38:31 AM

Item ID: 646.3511 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut
 Start Date: 6/13/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 6/13/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Weld per dwg. A/R S.S. rod Batch: <u>M125054</u>	0.00				<u>10</u>		<u>14-09-10</u>	<u>MAL</u>
Large Fab	Memo Weld tube to plate as per dwg. DT9867 Weld end were tube is punch.	0.00							
170 *170* QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00				<u>10</u>		<u>SEP 10 2014</u>	<u>DAS 24 9-89</u>
Quality Control	Memo	0.00							
180 *180* QC	QC5- Inspect part completeness to step on W/Q	0.00				<u>10</u>		<u>SEP 10 2014</u>	<u>DAS 24 9-89</u>
Quality Control	Memo	0.00							

Work Order ID 120292

June-20-14 10:38:31 AM

120292

Page 4

Item ID: 646.3511

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut

Start Date: 6/13/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/13/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

0.00

220

SprayPaint

Memo

0.00

Prime as per dwg (see note 3)

Spray Painting

Batch: 127401

DAS
41
9-89
14-9-11

10

230

QC14- Inspect Spray Paint

0.00

230

QC

Memo

0.00

Quality Control

10

10

10

14/09/12

240

0.00

240

Packaging

Memo

0.00

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND
REV***

Packaging

10X

14-9-15

8700K101

DAS
28
9-89

Work Order ID 120292

120292

Page 5

June-20-14 10:38:31 AM

Item ID: 646.3511

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut

Start Date: 6/13/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/13/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00

250

QC

Memo

0.00

Quality Control

14/9/16

14-9-15

Picklist Print

Monday, June 09, 2014 1:44:27 PM

Page 1

Work Order ID: 120292

120292

Parent Item: 646.3511

646.3511

Parent Item Name: Strut

Start Date: 6/13/14

Required Date: 6/13/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

sf

144.8670

①

DAS
23
9-89

M304S16GA

**

14-06-23

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

144.867

M127821

75.567

M128423

1.2

M129192

68.1

129.192

M304TR0.500W.049

Purchased

No

f

277.2805

18

M304TR0 500W 049

**

304 RD Tube .500 x .049W

Location

Loc Qty

Loc Code

MAT017

277.2805

M127937

201.634

M128833

75.6465

7.083'

14-09-02 MAL

~~M129192~~

~~M129192~~

x 7.083'

→

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04274

SHEET 1 OF 1

DWG NO. 646.3500

REV: NC

PREPARED
BY

J. SOTO

DATE: 12/02/2013

EFFECT ON DWG

☐ INC.

☒ UNINC.

DWG TITLE: STRUT

APPROVED BY:

ENGR

MFG

QC

EFF. NEXT ORDER

TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

REASON: REVISED DELTA NOTE 1 & 2.

SHEET 1, ZONE A1 IS:

IS

NOTES:

- 1 MATERIAL: AISI 304/ 316 SS SHEET .062 THK
(REF DART SPEC. M304S16GA)
- 2 MATERIAL: AISI 304/316 SS 0.500 OD X 0.049 WALL
(REF DART SPEC. M304TRO.500WO.049)
ENSURE SEAMLESS TUBE IS USED
- 3 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2
COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
4. DEBURR AND BREAK ALL SHARP EDGES
5. WELDS IAW MIL-STD-2219.
TIG WELD WITH FILLER ROD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120292 MLJ
14-06-06

DOCUMENTS EFFECTED:

☐ MDL

☐ INSTALL INSTRUCTIONS

☐ ICA

☐ FMS

☐ BOM

CHANGE CATEGORY

☐ MAJOR

☒ MINOR

DER REVIEW REQUIRED

☐ YES

☒ NO

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 02440

SHEET 1 OF 1

DWG NO. 646.3500 REV: NC

PREPARED BY

S. HUFF

DATE 06/08/09

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE:

STRUT

APPROVED BY:

ENGR

MFG

QC

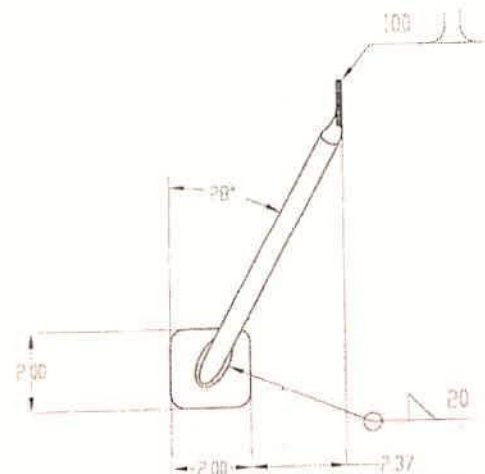
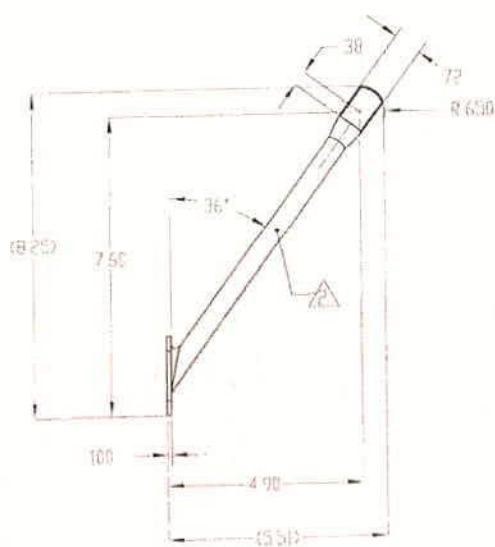
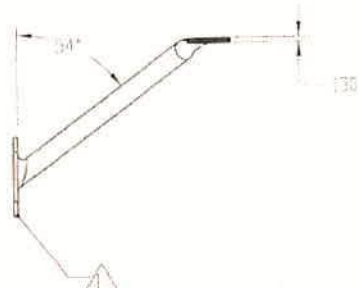
EFF:

CURRENT ORDER AND STOCK

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED GEOMETRY TO ACCOMMODATE NEW EXISTING AIRCRAFT PROVISIONS

SHEET 2 IS:



DOCUMENTS EFFECTED:

☐ MDL

☐ INSTALL INSTRU

☐ ICA

☐ FMS

☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES

☒ NO

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 02197

SHEET 1 OF 1

DWG NO. 646.3500 REV: N/C

PREPARED BY S. HUFF

DATE: 01/05/09

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE:

STRUT

APPROVED BY: ENGR *P. Brans*

MFG: *David Lake*

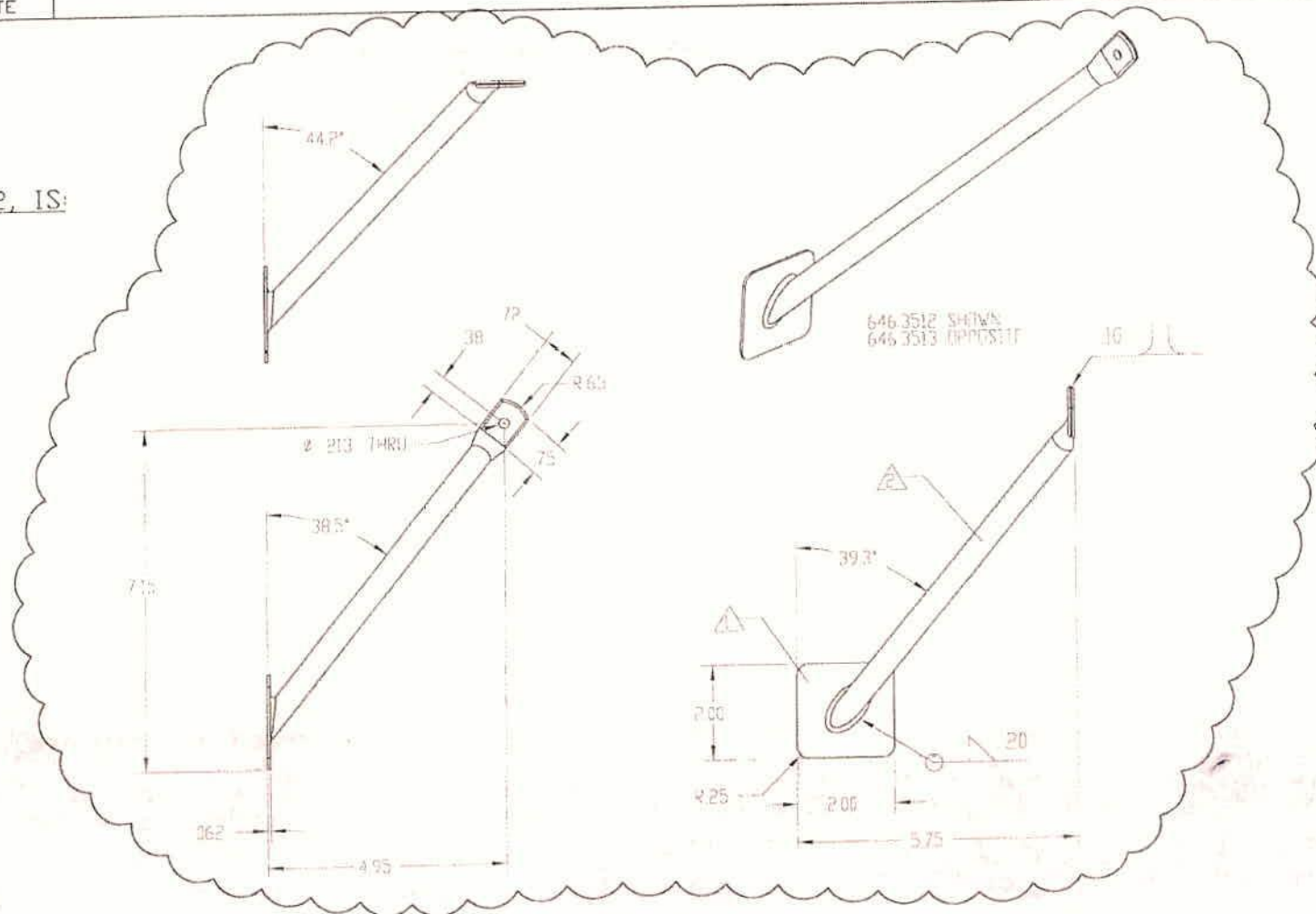
QC: *SS*

EFFECT: NEXT ORDER

TRANSACTION CODES (TC)
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED ANGLE OF 646.3512 & 646.3513 FOR BETTER FITMENT

SHEET 2, IS:



DOCUMENTS EFFECTED:

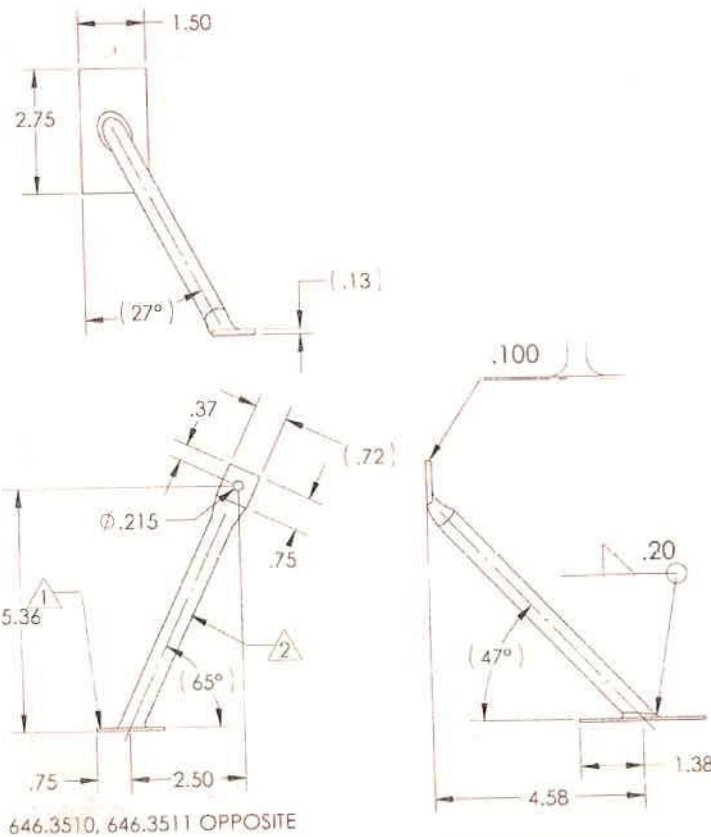
☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YFS ☒ NO

NOTES:

- 1 MATERIAL: 6061-T6 ALUMINUM IAW AMS-QQ-A-250/11;
.062" THK.
- 2 MATERIAL: 6061-T6 ALUMINUM IAW AMS-WW-T-700/6
.500" OD: .062" WALL THK
- 3 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2
COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
4. DEBURR AND BREAK ALL SHARP EDGES
5. WELDS IAW MIL-STD-2219.
TIG WELD WITH FILLER ROD



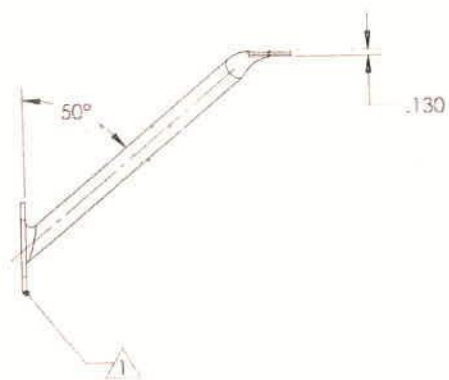
646.3510 SHOWN
646.3511 OPPOSITE

UNINCORPORATED ECN(s)

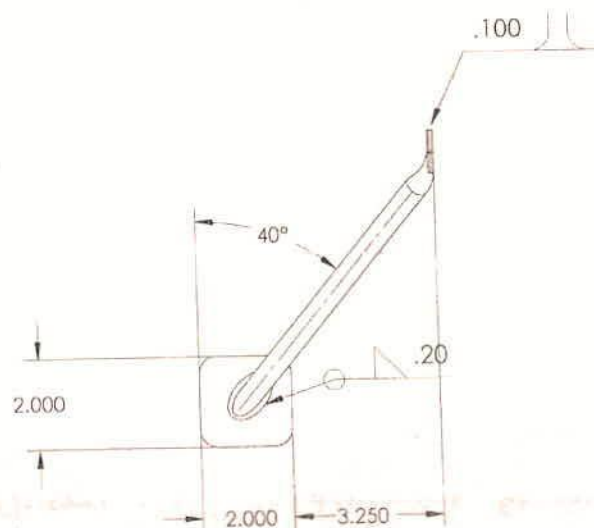
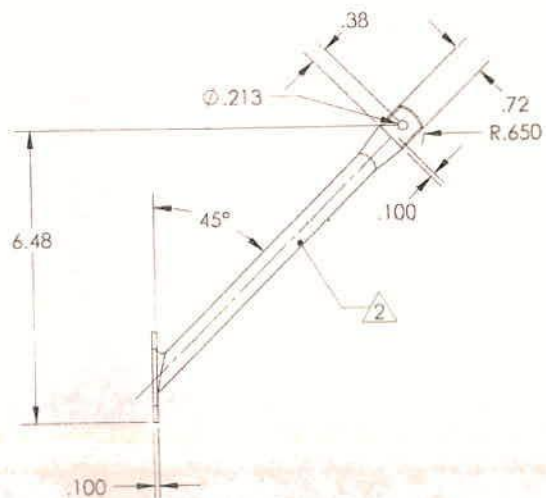
02197, 02440, 04274

		646.3513	STRUT	△△	△△
		646.3512	STRUT	△△	△△
		646.3511	STRUT	△△	△△
		646.3510	STRUT	△△	△△
	FOUND #	PART #	DESCRIPTION	MATL	SPEC
<div> <div>QTY</div> <div>REV</div> <div>DESCRIPTION</div> <div>MATL</div> <div>SPEC</div> </div>					
<div> <div>646.3510</div> <div>646.3511</div> <div>646.3512</div> <div>646.3513</div> <div>646.3514</div> <div>646.3515</div> <div>646.3516</div> <div>646.3517</div> <div>646.3518</div> <div>646.3519</div> <div>646.3520</div> <div>646.3521</div> <div>646.3522</div> <div>646.3523</div> <div>646.3524</div> <div>646.3525</div> <div>646.3526</div> <div>646.3527</div> <div>646.3528</div> <div>646.3529</div> <div>646.3530</div> <div>646.3531</div> <div>646.3532</div> <div>646.3533</div> <div>646.3534</div> <div>646.3535</div> <div>646.3536</div> <div>646.3537</div> <div>646.3538</div> <div>646.3539</div> <div>646.3540</div> <div>646.3541</div> <div>646.3542</div> <div>646.3543</div> <div>646.3544</div> <div>646.3545</div> <div>646.3546</div> <div>646.3547</div> <div>646.3548</div> <div>646.3549</div> <div>646.3550</div> <div>646.3551</div> <div>646.3552</div> <div>646.3553</div> <div>646.3554</div> <div>646.3555</div> <div>646.3556</div> <div>646.3557</div> <div>646.3558</div> <div>646.3559</div> <div>646.3560</div> <div>646.3561</div> <div>646.3562</div> <div>646.3563</div> <div>646.3564</div> <div>646.3565</div> <div>646.3566</div> <div>646.3567</div> <div>646.3568</div> <div>646.3569</div> <div>646.3570</div> <div>646.3571</div> <div>646.3572</div> <div>646.3573</div> <div>646.3574</div> <div>646.3575</div> <div>646.3576</div> <div>646.3577</div> <div>646.3578</div> <div>646.3579</div> <div>646.3580</div> <div>646.3581</div> <div>646.3582</div> <div>646.3583</div> <div>646.3584</div> <div>646.3585</div> <div>646.3586</div> <div>646.3587</div> <div>646.3588</div> <div>646.3589</div> <div>646.3590</div> <div>646.3591</div> <div>646.3592</div> <div>646.3593</div> <div>646.3594</div> <div>646.3595</div> <div>646.3596</div> <div>646.3597</div> <div>646.3598</div> <div>646.3599</div> <div>646.3600</div> <div>646.3601</div> <div>646.3602</div> <div>646.3603</div> <div>646.3604</div> <div>646.3605</div> <div>646.3606</div> <div>646.3607</div> <div>646.3608</div> <div>646.3609</div> <div>646.3610</div> <div>646.3611</div> <div>646.3612</div> <div>646.3613</div> <div>646.3614</div> <div>646.3615</div> <div>646.3616</div> <div>646.3617</div> <div>646.3618</div> <div>646.3619</div> <div>646.3620</div> <div>646.3621</div> <div>646.3622</div> <div>646.3623</div> <div>646.3624</div> <div>646.3625</div> <div>646.3626</div> <div>646.3627</div> <div>646.3628</div> <div>646.3629</div> <div>646.3630</div> <div>646.3631</div> <div>646.3632</div> <div>646.3633</div> <div>646.3634</div> <div>646.3635</div> <div>646.3636</div> <div>646.3637</div> <div>646.3638</div> <div>646.3639</div> <div>646.3640</div> <div>646.3641</div> <div>646.3642</div> <div>646.3643</div> <div>646.3644</div> <div>646.3645</div> <div>646.3646</div> <div>646.3647</div> <div>646.3648</div> <div>646.3649</div> <div>646.3650</div> <div>646.3651</div> <div>646.3652</div> <div>646.3653</div> <div>646.3654</div> <div>646.3655</div> <div>646.3656</div> <div>646.3657</div> <div>646.3658</div> <div>646.3659</div> <div>646.3660</div> <div>646.3661</div> <div>646.3662</div> <div>646.3663</div> <div>646.3664</div> <div>646.3665</div> <div>646.3666</div> <div>646.3667</div> <div>646.3668</div> <div>646.3669</div> <div>646.3670</div> <div>646.3671</div> <div>646.3672</div> <div>646.3673</div> <div>646.3674</div> <div>646.3675</div> <div>646.3676</div> <div>646.3677</div> <div>646.3678</div> <div>646.3679</div> <div>646.3680</div> <div>646.3681</div> <div>646.3682</div> <div>646.3683</div> <div>646.3684</div> <div>646.3685</div> <div>646.3686</div> <div>646.3687</div> <div>646.3688</div> <div>646.3689</div> <div>646.3690</div> <div>646.3691</div> <div>646.3692</div> <div>646.3693</div> <div>646.3694</div> <div>646.3695</div> <div>646.3696</div> <div>646.3697</div> <div>646.3698</div> <div>646.3699</div> <div>646.3700</div> <div>646.3701</div> <div>646.3702</div> <div>646.3703</div> <div>646.3704</div> <div>646.3705</div> <div>646.3706</div> <div>646.3707</div> <div>646.3708</div> <div>646.3709</div> <div>646.3710</div> <div>646.3711</div> <div>646.3712</div> <div>646.3713</div> <div>646.3714</div> <div>646.3715</div> <div>646.3716</div> <div>646.3717</div> <div>646.3718</div> <div>646.3719</div> <div>646.3720</div> <div>646.3721</div> <div>646.3722</div> <div>646.3723</div> <div>646.3724</div> <div>646.3725</div> <div>646.3726</div> <div>646.3727</div> <div>646.3728</div> <div>646.3729</div> <div>646.3730</div> <div>646.3731</div> <div>646.3732</div> <div>646.3733</div> <div>646.3734</div> <div>646.3735</div> <div>646.3736</div> <div>646.3737</div> <div>646.3738</div> <div>646.3739</div> <div>646.3740</div> <div>646.3741</div> <div>646.3742</div> <div>646.3743</div> <div>646.3744</div> <div>646.3745</div> <div>646.3746</div> <div>646.3747</div> <div>646.3748</div> <div>646.3749</div> <div>646.3750</div> </div>					
<div> <div>APICAL INDUSTRIES</div> <div>2608 TEMPLE HEIGHTS DR.</div> <div>CINCINNATI, OH 45226-2512</div> <div>(760)724-5300</div> </div>					
<div> <div>STRUT</div> <div>646.3500</div> </div>					
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ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE IN INCHES
 DIMENSIONS IN PARENTHESES ARE IN MILLIMETERS



646.3512 SHOWN
 646.3513 OPPOSITE



APICAL INDUSTRIES	
2608 TEMPLE HEIGHTS DR	
OCEANSIDE, CA 92056-3512 (760) 724-5300	
STRUT	
DATE: 01/01/00	REV: 01/01/00
BY: J. G. G. / J. G. G.	646.3500
SCALE: NONE	SHEET 2 OF 2